

Date: Thursday, 02/04/2009 2:22:42 PM
 User: Julie Dawson

Process Sheet

Customer	CU-DAR001 Dart Helicopters Services			Drawing Name	: FRAME		
Job Number	46824			Part Number	: D22521		
Estimate Number	13826			Drawing Number	: D2252 REV G		
P.O. Number				Project Number	: N/A		
This Issue	02/04/2009	S.O. No.		Drawing Revision	: G		
Prsht Rev.	NC			Material	:		
First Issue	/ /	Type	LARGE FAB ASSY	Due Date	14/04/2009	Qty:	8 Um: Each
Previous Run							
Written By							
Checked & Approved By	<u>JUL 09-04-08</u>						
Comment	Est Rev:A 09.03.18 New Issue EC verified by:DD						

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
✓ 1.0	M304TS0750W065	Scrap 1.5(f _s) 304 SQ Tube .75x.75x.065W	
		304 SQ Tube .75x.75x.065W	
		batch: <u>MU1331</u>	<u>SAD 09-04-08</u>
✓ 2.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1	
		Comment: LARGE FABRICATION RESOURCE 1	
		1- Cut as per dwg D2252	
		2- Deburr and remove identification markings on tube	
3.0	QC5	INSPECT WORK TO CURRENT STEP	
		Comment: INSPECT WORK TO CURRENT STEP	<u>SAD 09-04-08 (P)</u>
4.0	PACKAGING 1	PACKAGING RESOURCE #1	
		Comment: PACKAGING RESOURCE #1	
		Identify and Stock	
		Location: <u>CWA</u>	<u>SAD 09-04-08 (X)</u>
5.0	QC21	FINAL INSPECTION/W/O RELEASE	
		Comment: FINAL INSPECTION/W/O RELEASE	<u>SAD 09-04-08 (X)</u>
		Job Completion	
			<u>MF 09-04-08</u>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

ITEM	QTY -041	QTY -043	PART NUMBER	DESCRIPTION
1	X		D2252-041	BASKET ASSEMBLY
3		X	D2252-043	LID ASSEMBLY
7	2	2	D2221-1	RIB
8	5		D2235-1	RIB
9	2	2	D2252-1	FRAME
10		2	D2252-7	FRAME
11	1		D2252-9	FRAME
12	1		D2252-11	FRAME
13	1		D2252-13	FRAME
14	1		D2252-15	FRAME
15	4		D2252-17	FRAME
16		1	D2252-23	FRAME
17	2		D2253-1	LUG
18	2		D2254	GUSSET
19	1	1	D2327-3	BUSHING
20		1	D2329	LABEL PLATE
21	4	2	D2581	MOUNTING CHANNEL
22		2	D2989-19	RIB
23	3		D3748-1	HINGE HALF
24		3	D3749-1	HINGE HALF

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RELEASED
09/04/18 MB

WORK ORDER NO. A6220

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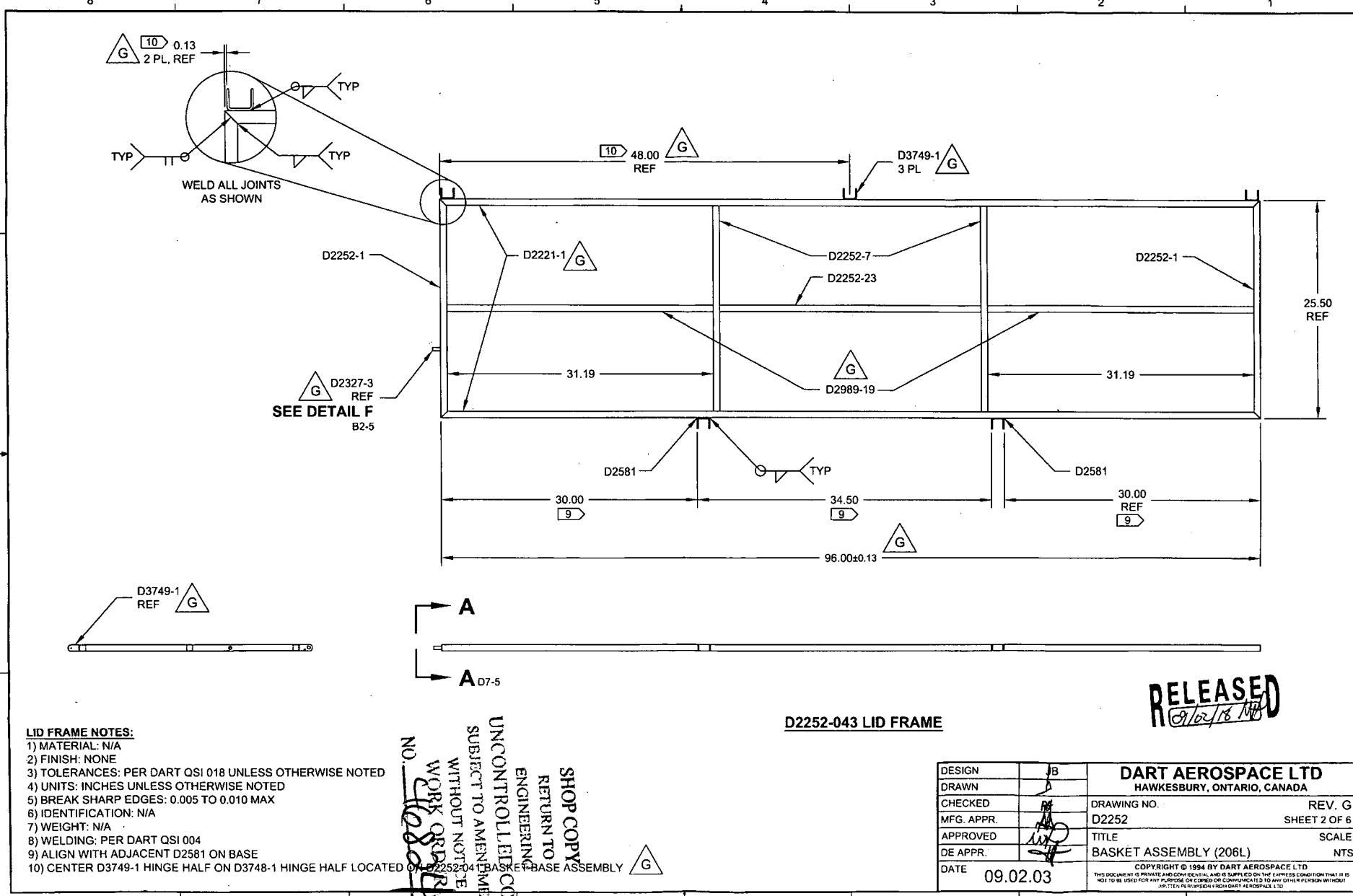
NOTES:

- 1) FRAME MATERIAL: AISI 304/316 SS, 3/4 x 3/4 x 0.065 WALL SQUARE TUBING
REF. DART SPEC M304TS0.750W.065
- 2) MESH MATERIAL: 3/4-16F EXPANDED SS
REF DART SPEC M304EX0.75-16F
- 3) FINISH: POWDER COAT ASSEMBLY GLOSS WHITE (4.3.5.2) PER DART QSI 005 4.3
- 4) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: N/A
- 7) IDENTIFICATION: N/A
- 8) WEIGHT: N/A
- 9) WELDING: PER DART QSI 004

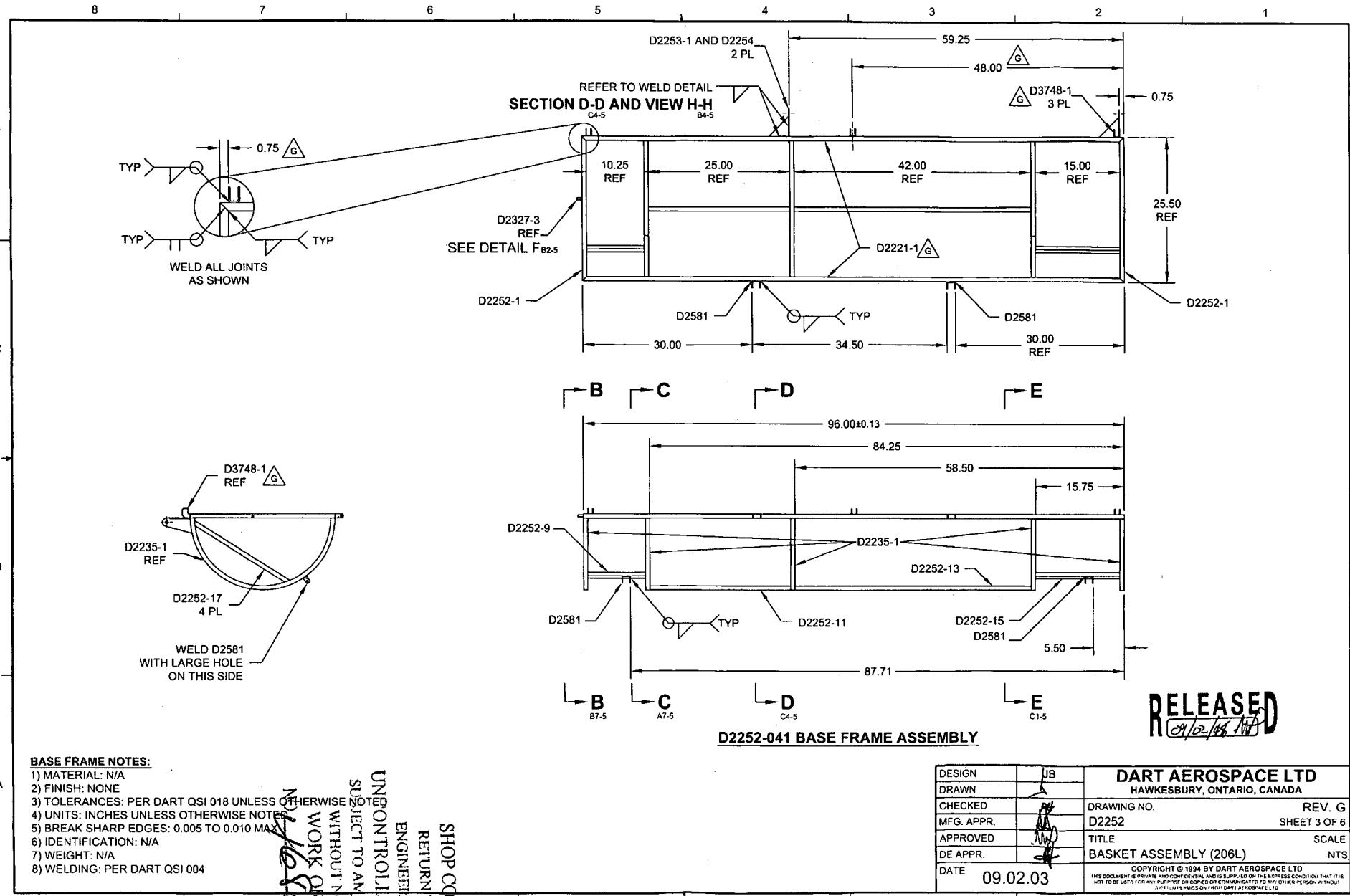
G	ADDED 'ITEM' COLUMN TO PARTS LIST; ADDED NOTE 10 ON SHT 2; ITEMS 23 AND 24 REPLACE D2232-1/I-3; STRETCHED LID FROM 95.27" TO 96.00"; ITEM 7 REPLACES D2252-3/I-19; ITEM 19 (ON LID) REPLACES D2327-1; ITEM 22 REPLACES D2252-21; UPDATED TOOLING (ZN A6-5). P/N REASON: SEE PAR#09-006.	MB	09.02.03
F	DRAWING UPDATED TO CURRENT STANDARDS. SHT 6 ADDED. SHT 2 VIEWS INVERTED FOR CLARITY. FRAME MATERIAL THICKNESS WAS 0.060.	AJS	08.08.11
E	INCORPORATED D1 & D2. ADDED D2231-1/I-3 & D2252-19.	MB	05.11.10
D	MODIFIED LATCH, D2581 WAS D2255-3	BK	99.09.14
C	RE-DRAWN	BK	95.12.11
REV.	DESCRIPTION	BY	DATE
DESIGN	JB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
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APPROVED			
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DATE	09.02.03		

DRAWING NO. REV. G
D2252 SHEET 1 OF 6
TITLE SCALE
BASKET ASSEMBLY (206L) NTS

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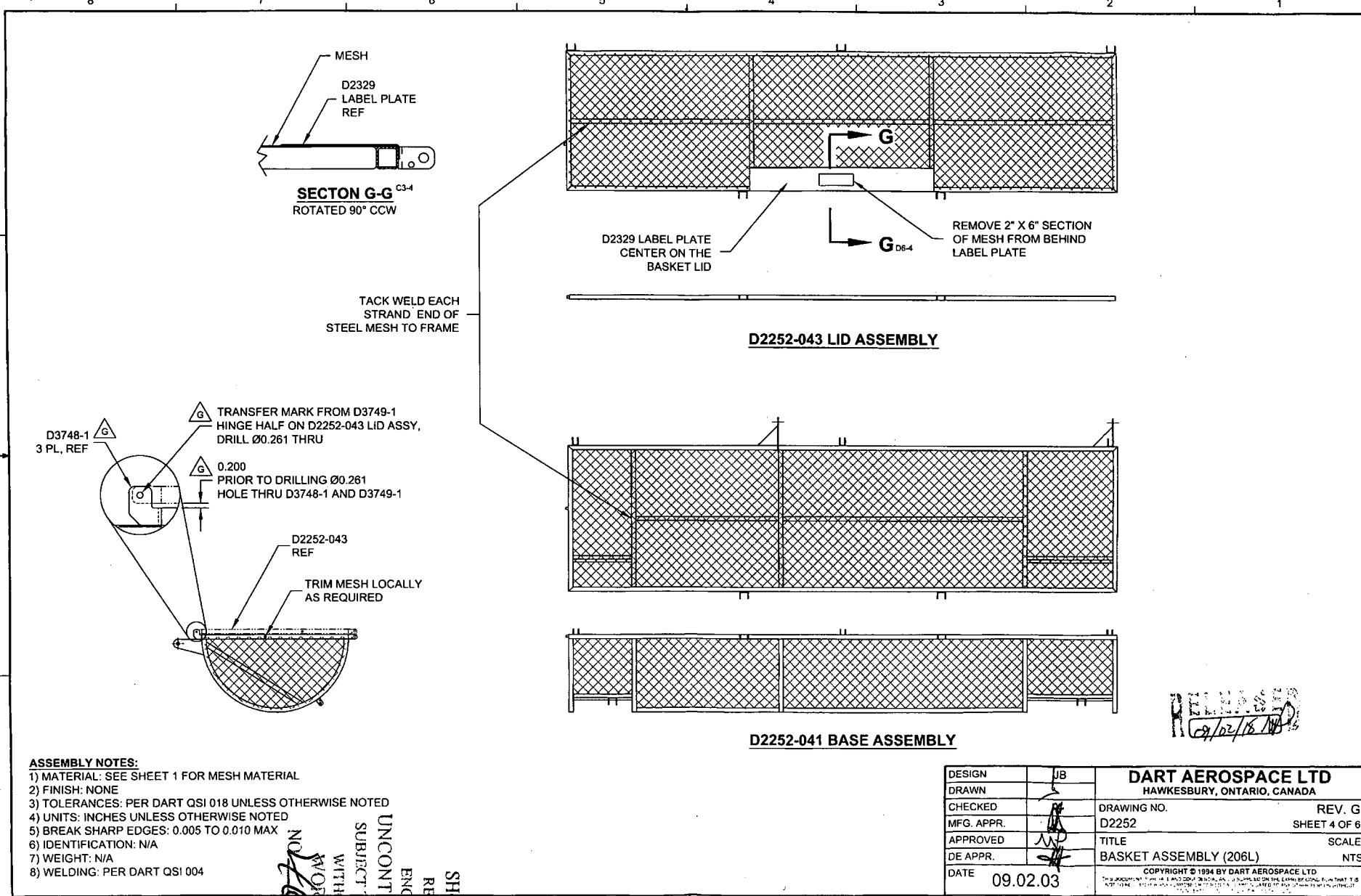


BASE FRAME NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI
- 4) UNITS: INCHES UNLESS OTHERWISE SPECIFIED
- 5) BREAK SHARP EDGES: 0.005
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: N/A
- 8) WELDING: PER DART QSI 004

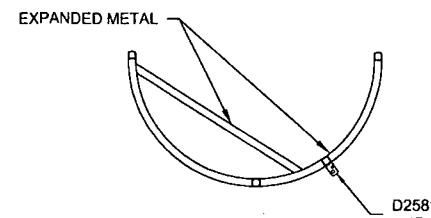
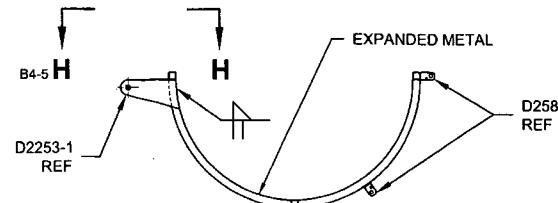
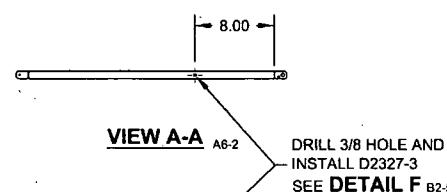
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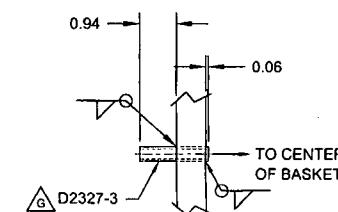
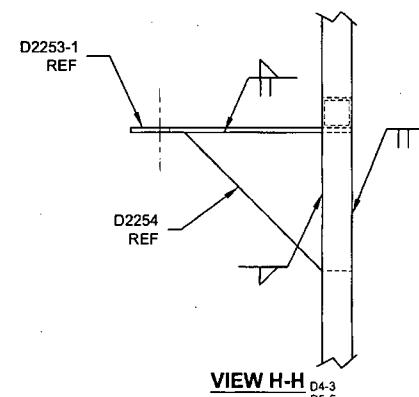
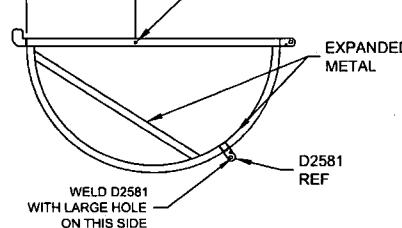


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